

Gray Urethane Surfacer

Programmed System Technique (PST)
Primers
05/26/2021

DESCRIPTION

Lesonal Gray Urethane Surfacer is intended for use as a high build surfacer that offers excellent filling, easy sanding, and fast dry times. Depending upon the mixing ratio used, Lesonal Gray Urethane Surfacer can also be used as a wet-on-wet primer sealer.

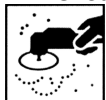
As A Primer Surfacer

Safety Considerations



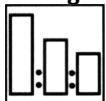
Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.

Preparation for Primer Surfacer



- Polyester bodyfiller final sanded with #P180 to #P220 grit sand paper dry.
- Existing OEM finishes final sanded with #P220 to #P360 grit sand paper dry.

Mixing



STICK #9

Mixing

Surfacer
3 Parts by volume Gray Urethane Surfacer
1 Parts by volume Urethane Surfacer Hardener
1 Parts by volume Lesonal Reducers
For high build applications, reducer is optional.
Accelerated mixing – add up to 2 capfuls or ½ ounce of Lesonal Accelerator per mixed ½ quart of paint.

Equipment



HVLP or Compliant Spray-Gun Set-Up:

1.8 – 2.0 mm

Application Air Pressure:

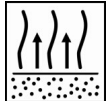
Consult spray gun manufacturers' specifications.
HVLP maximum 10 psi at the air cap.

Application



2 – 3 x 1 Coats

Flash-off



Flash Between Coats at 70°F (21°C)

- 5-10 Minutes between coats.

Flash at 70°F (21°C) Before Force Drying

- 5-10 Minutes before curing.

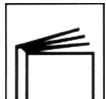
Drying time



Dry to Sand – 3 Coats

3-4 Hours at 70°F (21°C)
40 Minutes at 140°F (60°C)

Recoatable With



As a Sanded Primer Surfacer Recoatable with:

All Lesonal primer sealers
All Lesonal topcoats

Read complete TDS for detailed product information

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DESCRIPTION

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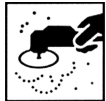
As A Primer Sealer

Safety Considerations



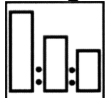
Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.

Preparation for Primer Sealer



- Aftermarket primed bumpers should be carefully prepped by slightly scuffing with 1000 grit paper
- Existing finishes final sanded with #P320 to #P400 dry or #P500 to #P600 wet sand paper.

Mixing



STICK #4

Mixing

- 2** Parts by volume Gray Urethane Surfacer
- 1** Parts by volume Urethane Surfacer Hardener
- 20%** Parts by volume Lesonal Reducer

Equipment



HVLP or Compliant Spray-Gun Set-Up:

1.3 – 1.5 mm

Application Air Pressure:

Consult spray gun manufacturer specifications.
HVLP maximum 10 psi at the air cap.

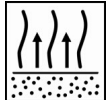
Application



1 x 1 Coats

On areas that have been sanded through, apply one thin coat and allow 5-10 minutes at 70°F (21°C) followed by a wet coat of sealer.

Flash-off



Flash before Topcoat at 70°F (21°C)

- 15 minutes minimum

Maximum Recoat Window at 70°F (21°C)

- 4 hours maximum

Recoatable With



As a Wet-On-Wet Primer Sealer Recoatable with:

All Lesonal topcoats

Read complete TDS for detailed product information

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PRODUCT AND ADDITIVES

Product	Lesonal Gray Urethane Surfacer	Item# 392616
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Hardeners	Lesonal Urethane Surfacer Hardener	Item# 395357
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Activators / Reducers	Lesonal Reducer Extra Slow	Item #394938
	Lesonal Reducer Slow	Item #394695
	Lesonal Reducer Medium	Item #394295
	Lesonal Reducer Fast	Item #394893
	Lesonal Reducer Extra Fast	Item #394318

Additives	Lesonal Accelerator	Item#397672
	Lesonal Flex Additive	Item#396027

METHOD OF USE

Suitable substrates	<ul style="list-style-type: none">Existing finishes cleaned and sanded with #P240 to #P320 grit paper dry or #P500 to #P600 grit wet.Steel cleaned and sanded with #P80 then #P180 grit dry.Lesonal Epoxy SealersFiberglass gelcoat cleaned and sanded with #P180 grit dryAutoPrep Self Etching PenAutoPrep Pretreatment WipesPolyester bodyfiller <p>Note: For large areas of bare metal, one coat of Lesonal Epoxy Primer Sealer is recommended for maximum corrosion resistance.</p>
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Basic Raw Materials	Gray Urethane Surfacer Primer	- Acrylic/polyester resins
	Lesonal Urethane Surfacer Hardeners	- Polyisocyanate resins
	Lesonal Reducers	- Solvent blend

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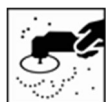
Substrate preparation



Pre-cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with Lesonal Surface Cleaner, Autoprep Ultra Prep or Antistatic surface cleaners.
- Avoid saturating body filler with water or cleaners while washing the repair.

Sanding Preparation



	Gray Urethane Surfacer (Surfacer)	Gray Urethane Surfacer (Sealer)	
	Dry Sanding	Dry Sanding	Wet Sanding
Existing Finishes	#P220 to #P360	#P320 – #P400	#P500 – #P600
OEM E-Coat	#P320 to #P400	#P320 to #P400	#P500 – #P600
Aftermarket Primed Bumpers	N / A	Carefully sand with #P1000	N / A
Polyester Bodyfiller	#P180 to #P220	N / A	N / A
Steel	#P80 then #P120	#P80 then #P120	N / A
Gel-Coat	#P220 to #P360	#P320 – #P400	#P500 – #P600
Polyolefin Plastic	#P320 to #P400	#P400	#P500 – #P600
Non-Polyolefin Plastic	##P320 to #P400	#P320 – #P400	#P500 – #P600



Surface Cleaning



- Clean with Surface Cleaner, Autoprep UltraPrep or Antistatic surface cleaners prior to priming.

PRE-TREATMENT OF BARE SUBSTRATES

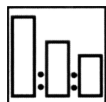
Pre-Treatment

- Gray Urethane Surfacer provides adequate adhesion to small bare metal areas. For larger areas or for improved corrosion protection Gray Urethane Surfacer should be applied over a metal pre-treatment such as the Autoprep Pre-Treatment Wipes or Autoprep pen materials.
- Polyolefin plastics require a pre-treatment adhesion promoter. Prime polyolefin plastics with All Plastic Primer prior to the application of flexed Gray Urethane Surfacer. For more information about painting plastic refer to the All Plastic Primer Technical Data Sheet.

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Mixing – Primer Surfacer

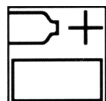


STICK #9

Mixing
3 Surfacer
Parts by volume Gray Urethane Surfacer
1 Parts by volume Urethane Surfacer Hardener
1 Parts by volume Lesonal Reducers
For high build applications, reducer is optional.

Accelerated mixing – add up to 2 capfuls or ½ ounce of Lesonal Accelerator per mixed ½ quart of paint.

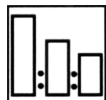
Mixing – Primer Surfacer with Accelerator



Only use accelerator in Gray Urethane Surfacer - Surfacer. Do not add more than stated amount to maintain product quality.

Accelerated Surfacer
Gray Urethane Surfacer - Surfacer – Mixed ready to spray with hardener and activator.
1/2 quart
+
½ ounce
OR Lesonal Accelerator and stir thoroughly.
(5 mL)

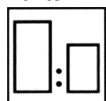
Mixing – Primer Sealer



STICK #4

Mixing
2 Parts by volume Gray Urethane Surfacer
1 Parts by volume Urethane Surfacer Hardener
20% Parts by volume Lesonal Reducer

Mixing – Flexible Parts

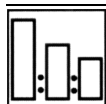


If the part to be can be deformed by hand, increase the flexibility of Gray Urethane Surfacer as follows.

Mixing **Make a Mixture of**
5 Parts by volume Gray Urethane Surfacer
1 Parts by volume Flex Additive

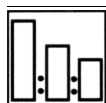
A mixture of 3:1 should be used for soft parts.

Stir the paint and Flex Additive mixture together then step #2 mix surfacer or sealer



STICK #9

Mixing **Surfacer**
3 Parts by volume Gray Urethane Surfacer / Flex Additive (Previous step)
1 Parts by volume Urethane Surfacer Hardener
1 Parts by volume Lesonal Reducers

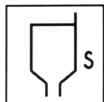



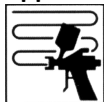
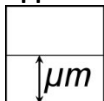


STICK #4

Mixing **Sealer**
2 Parts by volume Gray Urethane Surfacer / Flex Additive mixture (Previous step)
1 Parts by volume Urethane Surfacer Hardener
20% Parts by volume Lesonal Reducers

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Viscosity When Mixed	Seconds 23-30 16-17	Measured with a DIN #4 viscosity cup at 70°F (21°C). Gray Urethane Surfacer - Surfacer – Sanding Gray Urethane Surfacer - Sealer – Non-Sanding
		
Pot-life when Mixed	Product Mix	70°F (21°C)
	Gray Urethane Surfacer Primer Surfacer Gray Urethane Surfacer Primer Surfacer – With Lesonal Accelerator Gray Urethane Surfacer Sealer	1 hour 30 Minutes 60 Minutes
Spray Gun Set-Up SURFACER	Consult spray gun manufactures instructions for specific spray gun pressure specifications.	
	Surfacer Spray Guns	Fluid Tip
	HVLP Gravity Fed	1.8 – 2.0mm
	Compliant Gravity Fed	1.7 –2.2mm
	Application Pressure	29 psi at the spray gun inlet (Maximum 10 psi at cap). 29 to 35 psi at the spray gun inlet.
Spray Gun Set-Up SEALER	Sealer Spray Guns	Fluid Tip
	HVLP Gravity Fed	1.3 – 1.5mm
	Compliant Gravity Fed	1.3 – 1.5mm
	Application Pressure	29 psi at the spray gun inlet (Maximum 10 psi at cap). 29 to 35 psi at the spray gun inlet.
Application	Primer Surfacer	
	<ul style="list-style-type: none"> • Apply 2-3 single wet coats. For use on repair (polyester bodyfiller) or sanded areas apply one coat over the repair, and then after a flash dry apply the second and third coats. • Flash off between the coats until the surface becomes totally matte, this will depend on ambient temperature, applied thickness/wetness and airflow. 	
	Primer Sealer	
	<ul style="list-style-type: none"> • Apply 1 thin but flowing coat over the desired area. <p>Over any sand through areas, first apply a thin coat to make all the substrate layers uniform before continuing with a normal coat.</p>	
Film Thickness – Using Suitable Application	Primer Surfacer	
	<ul style="list-style-type: none"> • 1 Coat will achieve a thickness of 2.0-2.5 mils (50-75µm). 	
	Primer Sealer	
	<ul style="list-style-type: none"> • 1 Coat will achieve a thickness of 1.2-1.5 mils (30-37.5µm). 	

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DRYING / CURING TIME

Drying / Curing Time – Primer Surfacer



Times are stated following recommended application method, film thickness and object temperature.

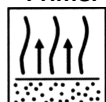
Primer Surfacer Air Dry

- 3-4 hours at 70°F (21°C)
- 2-3 hours at 70°F (21°C) when mixed with Lesonal Accelerator.

Primer Surfacer Force Dry Bake

- 40 Minutes at 140°F (60°C)
- 30 Minutes at 140°F (60°C) when mixed with Lesonal Accelerator.

Drying Flash Time – Primer Sealer

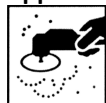


Primer Sealer Flash Time

- Prior to top-coating primer sealer, allow a minimum flash off time of 15 minutes at 70°F (21°C).
- Maximum recoat time is 4 hours 70°F (21°C).

If the maximum flash time be exceeded, Gray Urethane Surfacer sealer must be sanded prior to topcoat application, with #P500 to #P600 dry or #P800 wet sand paper.

Final Preparation – For Top Coat Application



Dry Sanding – Machine

- When dry sanding, respect a maximum 200 sanding grit step or less throughout sanding.
- Initial sanding may be done with #P320 to P400.
- Final sanding should be done using #P500 to #P600 before application of Lesonal topcoats.

Wet Sanding – By Hand



- When wet sanding, respect a maximum 200 sanding grit step or less throughout sanding.
- Initial sanding may be done with grits courser than #P600.
- Final sanding should be completed using #P800 before application of Lesonal top-coats.

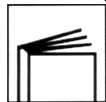
Surface Cleaning



- Clean with Surface Cleaner, Autoprep UltraPrep or Antistatic surface cleaners prior to topcoating.

POST-APPLICATION

Recoating



- Lesonal Gray Urethane Surfacer can be recoated with all Lesonal sealers and topcoats.

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ADDITIONAL INFORMATION

Cleaning of Equipment



Clean equipment following local and federal regulations. For national rule regions, use Lesonal Cleaning Solvent or high-quality lacquer thinner.

Theoretical Coverage



By using the recommended application, the theoretical material usage for 1 mils RTS

		ft ² /gallon	m ² /liter
Sanding (mixture A)	RTS @ 3:1:1	659±5	16.2±2

The practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances.

VOC / Regulatory Information



System

Primer Surfacer
Primer Sealer

Mix Ratio

3:1:1
2:1:20%

VOC

≤3.85 lbs/gal (≤462 g/L)
≤3.93 lbs/gal (≤471 g/L)

Product Storage



Gray Urethane Surfacer
Gray Urethane Surfacer Hardener

2 years
1 year

Gray Urethane Surfacer

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